

The history of the United States Mint goes back to the Presidency of George Washington and to the time Philadelphia was the nation's capital.

The Mint, in fact, was the first public building erected by the United States Government. It has grown from a small cluster of brick buildings dating from 1792 to the present pink granite structure covering three city blocks and housing the most modern coinage equipment in the world.

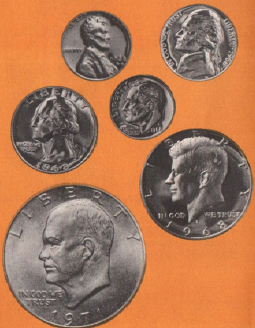
The Act of April 2, 1792 provided for a national coinage and the establishment of the U.S. Mint. The first coins were pattern silver half dimes made by hand from silver plate belonging to George Washington. In 1793 copper cents and half cents were the first coins manufactured for the public to use.

In the first eight years of the Mint's history only one million coins were struck. Today the capability is one million coins per hour.

In all there have been 19 different kinds of coins issued for circulation — from the 20 dollar gold coins to three, two and half-cent pieces. Presently the mint manufactures six denominations — one cent pieces, five cents, dimes, quarters, half-dollars, and dollars.

The Philadelphia Mint is part of a country-wide Treasury agency known as the Bureau of the Mint. From headquarters in Washington, D.C., the Director of the Mint administers the Philadelphia and Denver Mints, the Assay Offices at New York City, and at San Francisco, and the Depositories at Fort Knox, Ky. and West Point, N.Y. for the storage of gold, silver and other coinage metals.

The public is welcome to visit the mint every day except Saturday, Sunday and holidays. The hours are from 9 A.M. to 3:30 P.M. No reservations are necessary.



# How TO MAKE A PENNY

## AT THE PHILADELPHIA MINT



A lot of people save pennies. Many more people just put them in a drawer and forget about them. That's too bad. Pennies are needed in the world of business. If all the forgotten pennies were brought out of hiding and used, it would save the mint a lot of time and money making more and more pennies every year.

The penny is our country's most popular coin and the mint makes more pennies than any other coin. In fact, 76 percent of all the coins made each year are pennies. This year the mint plans to make 5 1/2 billion pennies.

Pennies are made of two metals. They are 95 percent copper and 5 percent zinc. "Nickels" are also made of two metals. They are 75 percent copper but only 25 percent nickel.

All other coins are called composite coins because they are made in three layers. The outside layers are cupro-nickel and the middle layer is pure copper. Dimes, quarters and half-dollars all have three layers as does the new dollar coin first issued in the fall of 1971. The layers must be bonded together. This is called cladding.

The Philadelphia Mint has the best coinage equipment in the world including all the machines to make clad coins. The explanation of clad coins does not appear in this pamphlet but you will see the machines on your tour.

Commemorative and other special medals are also made at the Mint. These medals are made to honor an historic event, or a President, or a spectacular achievement.



**MAKE-UP**

The make-up box is weighed on a floor scale. It's called a make-up box because it holds the raw metal from which coins are made up. A big crane picks up the box and takes it to the melting furnace.



**MELTING**

The furnace is electric and gets red hot. When the metal is put inside the furnace it melts. The furnace is big enough to hold 15,000 pounds of metal.



**CASTING**

The melted metal is poured into a mold that looks like a giant candy bar. The bar is called an ingot. When the melted metal cools it gets hard again. The bar is about 18 feet long and weighs about 7,000 pounds.



**CROPPING SAW**

Each bar is cut in half. Now there are two bars. They are called slabs. Each one must be 8 and a half feet long and weigh 3,300 pounds. Any scrap is sent back to the furnace. Nothing is wasted.



**REHEAT FURNACE**

This is another electric furnace that heats the slab to just the right temperature so it will be soft enough to be rolled out.



**ROLLING LINES**

The slab is red hot and is six inches thick. Many things happen here:

First the slab squeezes through a pair of rollers. The rollers are so close together and press down so hard that when the slab comes out after several trips back and forth it is only one-half inch thick.

The rolled out slab is still red hot. It must be cooled to room temperature. Now it is sent through two sprays of water to cool it.

The top and bottom of the slab must be smooth. A machine shaves the top and bottom. The shavings go back to the melting furnace. The strip is now smooth and bright and so thin it can be rolled up into a coil.

Even though the coiled strip is very thin it is not thin enough. So the strip is uncoiled and put through a second rolling mill. When it comes out it is only a tenth of an inch thick.

When uncoiled the strip is about 400 feet long. Sometimes two or more of the uncoiled strips are welded together to make a strip even longer. Rough edges are trimmed off the strip to make it smooth. Now the coil is rolled down in the third rolling mill to one-twentieth of an inch thick, 15 inches wide.



**INSPECTION, COUNTING AND BAGGING**

At last we have a penny! Bad pennies are not allowed to leave the mint. Good pennies go to the counting machine. After 5,000 pennies fall into the bag a sewing machine sews the bag shut. The bags go to the Federal Reserve Bank. Then the pennies go to you.



**COINING PRESS**

The shiny golden penny blanks are ready to receive the impression of President Lincoln's portrait on one side and the Lincoln Memorial on the other. The designs are impressed from hard steel coinage dies onto the blank. Fingers on the press firmly grab each blank and one heavy blow stamps the design on each side.



**UPSETTING MILLS**

The blanks roll on their edges through this machine. They are soft enough so that when the machine presses on them it raises a rim around the blanks.



**ANNEALING AND CLEANING LINES**

The blanks are put into a gas furnace to be softened again. (Annealing means to soften). They come out of the furnace red hot and drop into water to cool. The blanks are then cleaned and polished. Then they are rinsed off with water and dried.



**BLANKING PRESS**

The strip is ready for punching out round pieces of metal about the size of a penny. They are called blanks, or planchets. This machine works just like a cookie cutter. After the blanks are punched out any strip left over is sent back to the make-up box.